



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship May 24
Order 5752
03469

648.4704

Job Sheet 176747



①

Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul Kit



Part Weight: 0 lbs

Status: Scheduled *At Planning*

Priority: Medium

Job Created: 4/30/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/24/18	5/24/18	0.00	0.00	Start Up Small Fab-3		<i>18-0005</i>
100	Small Fab	1 pcs	5/24/18	5/24/18	0.00	1.00	Small Fab-3		<i>38</i>
120	QC	1 pcs	5/24/18	5/24/18	0.00	0.00	QC4		<i>9-88</i>
121	DC	1 pcs	5/24/18	5/24/18	0.00	0.00	DC		<i>21</i>
130	Packaging	1 pcs	5/24/18	5/24/18	0.00	0.00	Packaging3-1		<i>21</i>
140	QC21-FG	1 Ea	5/24/18	5/24/18	0.00	0.00	QC21		<i>21</i>

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

Fg. sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P✓	Washer ✓	3 Ea (3 ea)	90-Start up Operation	<i>5056461</i>
NAS1149F0563P✓	Washer ✓	8 Ea (8 ea)	90-Start up Operation	<i>5054114</i>
188-FPSS-1/4 20-3/8✓	Set Screw ✓	2 Ea (2 ea)	100-Small Fab	<i>5048558</i>
188-FSCS-1032-5/8✓	Screw ✓	4 Ea (4 ea)	100-Small Fab	<i>5037012627 57</i>
600.1309-A✓	Label ✓	1 Ea (1 ea)	100-Small Fab	<i>5029592 5064516</i>
600.1312✓	Caution Sticker ✓	1 pcs (1 ea)	100-Small Fab	<i>5075069</i>
AN4-23A✓	Bolt ✓	2 Ea (2 ea)	100-Small Fab	<i>F123434-40</i>
AN5-21A✓	Bolt ✓	4 Ea (4 ea)	100-Small Fab	<i>5057451</i>
C2-14-2✓	Label Rivets ✓	2 Ea (2 ea)	100-Small Fab	<i>5057170</i>
C45-10-1✓	Spring Pin ✓	1 Ea (1 ea)	100-Small Fab	<i>5040658</i>
C45-10-2✓	Lock Spring ✓	1 Ea (1 ea)	100-Small Fab	<i>5048643</i>
C45-11-2✓	Locating Pin ✓	2 Ea (2 ea)	100-Small Fab	<i>5029297</i>
C45-12-1✓	Lock Bushing ✓	2 Ea (2 ea)	100-Small Fab	<i>5060915</i>
C45-12-6✓	Retaining Ring ✓	2 Ea (2 ea)	100-Small Fab	<i>5029303</i>
C45-13-1✓	Keeper Bushing ✓	2 Ea (2 ea)	100-Small Fab	<i>5067580</i>
C45-13-2✓	Spacer ✓	2 Ea (2 ea)	100-Small Fab	<i>5029305</i>
C45-13-5✓	Keeper Spring ✓	1 Ea (1 ea)	100-Small Fab	<i>5029308</i>
C45-3-1✓	Radial Bearing ✓	2 Ea (2 ea)	100-Small Fab	<i>5052562</i>
C45-3-12✓	DU Bearing ✓	1 Ea (1 ea)	100-Small Fab	<i>5053842</i>
C45-3-2-1✓	Snap Ring ✓	2 Ea (2 ea)	100-Small Fab	<i>5029317</i>
C45-3-4-1✓	Retaining Ring ✓	4 Ea (4 ea)	100-Small Fab	<i>5029320</i>
C45-3-5✓	Spacer ✓	2 Ea (2 ea)	100-Small Fab	<i>5029321</i>
C45-3-8A✓	Actuator Shaft Bushing ✓	1 Ea (1 ea)	100-Small Fab	<i>5074268</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																															
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																													
Description Work Order Deviation			Disposition																																																														
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S075067 Part: 648.4704 Job No: 176747 Serial No/Batch: S075067 Revision: 4 Inspector: _____ Date: 05/28/18			Completed By																																																														
			Lead hand / Supervisor Approval Verification																																																														
			QC / QA Coordinator Approval																																																														
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>			Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%;"> <tr> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Misaligned/off center</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Misread</td> <td>☐ Turning Sequence</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Over/Under tolerance</td> <td>☐ Part Incorrect</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Part Moved</td> <td>☐ Drawing</td> <td>☐ Finish</td> </tr> </table>			☐ Instructions Incomplete/Unclear	☐ Misaligned/off center	☐ Positioned Wrong	☐ Misread	☐ Turning Sequence	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish
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Marks/Chatter ☐ OTHER : _____			Drill Holes ☐																																																														

C45-3-8B ✓	Actuator Shaft Bushing ✓	1 Ea (1 ea)	100-Small Fab
C45-3-9 ✓	Lever Spring ✓	1 pcs (1 ea)	100-Small Fab
C45-4-1 ✓	Trunnion Bushing ✓	2 Ea (2 ea)	100-Small Fab
C45-5-1 ✓	Lever Stop Pin ✓	1 Ea (1 ea)	100-Small Fab
C45-7-1 ✓	LOADBEAM BUMPER ✓	1 Ea (1 ea)	100-Small Fab
C45-7-2 ✓	Lock Bumper ✓	2 Ea (2 ea)	100-Small Fab
C45-8-4 ✓	Solenoid Cover Gasket ✓	1 Ea (1 ea)	100-Small Fab
MS21044N5 ✓	Nut ✓	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw ✓	1 Ea (1 ea)	100-Small Fab

5029324 / 1804266
 5029325
 5074149
 5029329
 5029332
 5075337
 5029336
 5057526
 5039330

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	472	0
	NAS1149F0563P	8	161	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	46	0
	188-FSCS-1032-5/8	4	257	0
	600.1309-A	1	0	0
	600.1312	1	0	0
	AN4-23A	2	600	0
	AN5-21A	4	53	0
	C2-14-2	2	264	0
	C45-10-1	1	94	0
	C45-10-2	1	16	0
	C45-11-2	2	42	0
	C45-12-1	2	22	0
	C45-12-6	2	48	0
	C45-13-1	2	0	0
	C45-13-2	2	86	0
	C45-13-5	1	95	0
	C45-3-1	2	26	0
	C45-3-12	1	17	0
	C45-3-2-1	2	58	0
	C45-3-4-1	4	64	0
	C45-3-5	2	80	0
	C45-3-8A	1	0	0
	C45-3-8B	1	0	0
	C45-3-9	1	0	0
	C45-4-1	2	2	0
	C45-5-1	1	16	0
	C45-7-1	1	0	0
	C45-7-2	2	2	0
	C45-8-4	1	11	0
	MS21044N5	4	99	0
	MS27039-4-08	1	86	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					